

# Work Order ID 51182

August 6, 2009 1:24:41 PM



Page 1

Item ID: D3266-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3266

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut (4) D2236 From D3166-3 1/2-Cut 3/4" x 3/4" square tubing as per Dwg D3266 3-Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305 4-Deburr & Remove all markings from material 15-Weld as per Dwg D3266 using Welding Table and corner Jig De

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SP 09.08.13  
SY 09.10.17

PD 09.08.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51182

August 6, 2009 1:24:41 PM



Page 2

Item ID: D3266-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 8/21/08

(X0) P

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

M112260

0.00

1ST COAT: START TIME: 4:15am OVEN  
TEMPERATURE: 400°F FINISH TIME: 4:45am  
10:00am 2ND COAT: START TIME: OVEN  
TEMPERATURE: 10:30am FINISH TIME: 4:00°F

\* pressure wash

09-08-18

(X0) P

140

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

M112100

0.00

Wing Walk Batch: M112100 Hand Spray Paint black  
Batch: M11283 11as per Dwg D3266and QSI 005 4.4

MD 09/08/18

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51182

August 6, 2009 1:24:41 PM



Page 3

Item ID: D3266-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Lid Assembly

Start Date: 8/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/19/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

⇒ 509/08/15



QC

Memo

0.00

Quality Control

ⓧ φ  
PAP5180 8/18/20

160

QC21- Final Inspection - Work Order Release

0.00

09/08/26 PJ, BR 09-8-24



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 6, 2009 1:24:40 PM

Page 1

14

Work Order ID: 51182

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly


Comments:

Start Date: 8/10/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-1RevC		Manufactured	No			100	Each	22.0000	2.0000			
												
Basket Hinge												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

20

50896

20

2x 09/08/12

D2327-1RevD

Manufactured

No

100

Each

6.0000

2.0000



Spacer Bushing

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

6

46325

6

D2506RevF

Manufactured

No

100

Each

3.0000

1.0000



Label Plate

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

3

44275

1

50027

2

B51135

09/08/12 B51311

09/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

August 6, 2009 1:24:40 PM

Work Order ID: 51182

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 8/10/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	49.0000	2.0000			
												
Mounting Bracket												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    5



46086    2

48428    3

Main Warehouse

WA    44

50872    44

D3166-3RevA1		Manufactured	No			100	Each	7.8105	1.0000			
												

Basket Hoop

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA    7.8105

50033    1.8105

50618    6

2 x *SH* 09/08/12

*1* SP 09.08.13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 6, 2009 1:24:40 PM

Work Order ID: 51182

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 8/10/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	736.7735	10.0000			



Expanded Metal Flat SS



SAD 09-08-13

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	736.7735065	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	4.14	
111630	9.15	
111956	6.335517	
112147	121.877989	
112311	448	

10.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 6, 2009 1:24:40 PM

Work Order ID: 51182

Parent Item: D3266-041RevB

Parent Item Name: Basket Lid Assembly

Comments:

Start Date: 8/10/09

Required Date: 8/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	668.8315	28.4211			

304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

68.83151369

111148

0.484

111432

0.44

111885

1.5682

112051

7.3691E-05

112263

66.33924

Main Warehouse

WA

600

112344

600

B 112344

END BAR  
Scrap

26.9 Sp 09.08.13.  
1.7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	PART NUMBER	DESCRIPTION
X	D3266-041	BASKET ASSEMBLY
2	D2232-1	HINGE PLATE
4	D2236	RIB
2	D2327-1	BUSHING
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3266-1	RIB
2	D3266-3	RIB
6	D3266-5	RIB
3	D3266-7	RIB

Wb  
5182

RELEASED  
08-09-04/11



**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF: DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

B	INCORPORATED A1. DRAWING UPDATED TO CURRENT STANDARDS. SHEET 5 ADDED. RIB MATERIAL WAS 0.060 THICK.	AJS	08.08.15
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AM	DRAWING NO.	REV. B
MFG. APPR.	EF	D3266	SHEET 1 OF 5
APPROVED	EF	TITLE	SCALE
DE APPR.	EF	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

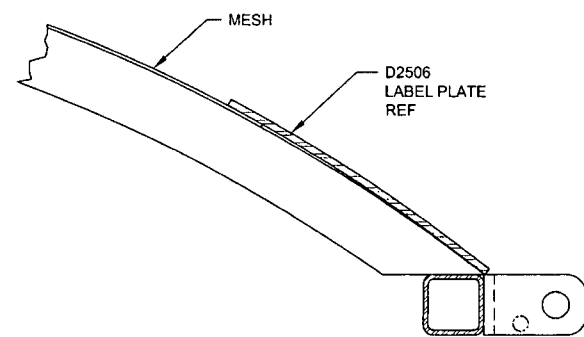
8 7 6 5 4 3 2 1

D

C

B

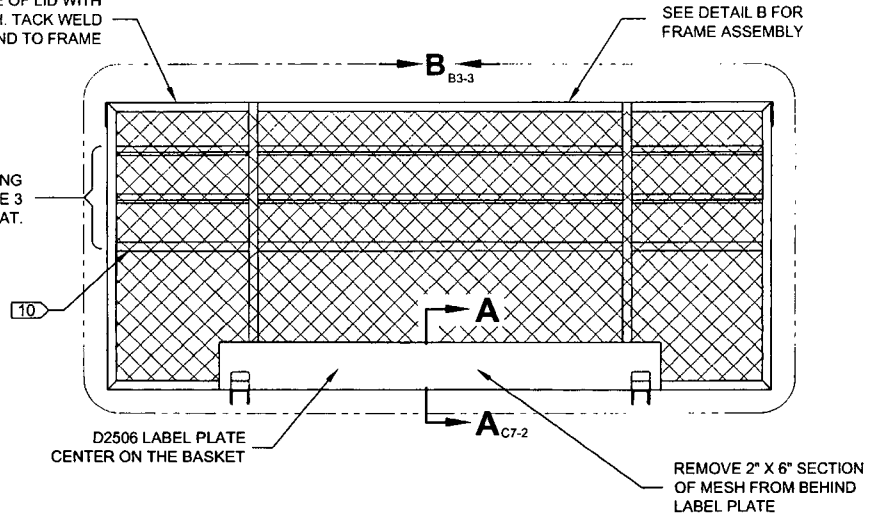
A



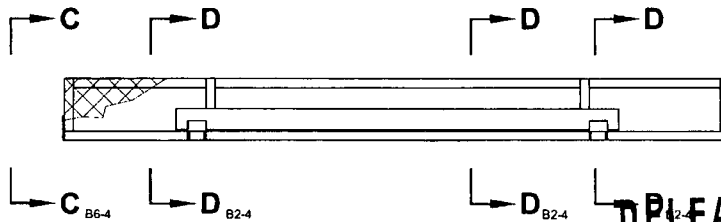
**SECTION A-A**  
(ROTATED 90° CCW)  
SCALE NONE

SKIN OUTSIDE SURFACE OF LID WITH  
SS MESH. TACK WELD  
EACH END STRAND TO FRAME

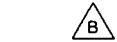
FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.



**D3266-041 BASKET LID ASSEMBLY**







**RELEASED**  
18-07-04/18



**ASSEMBLY NOTES:**

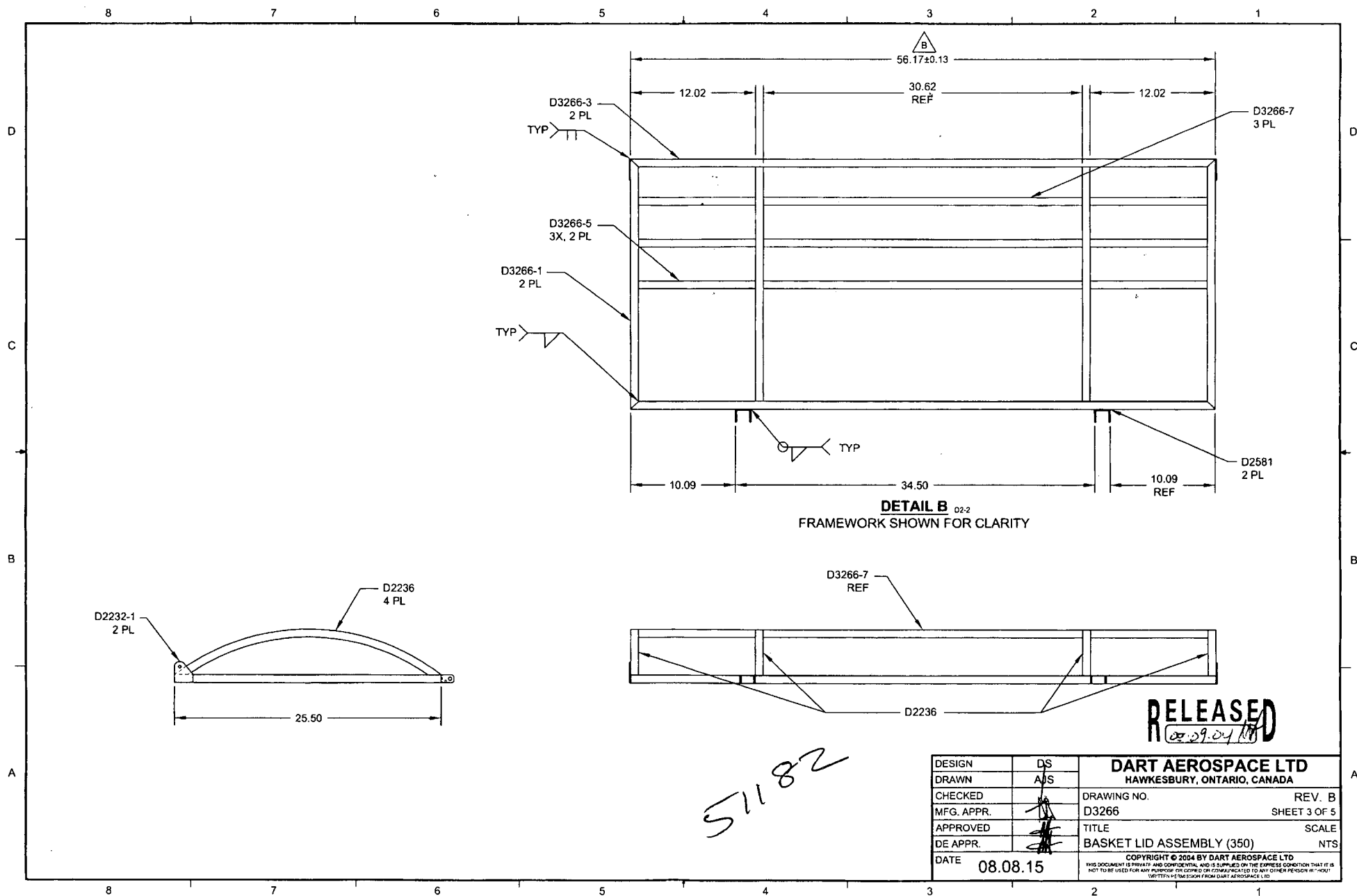
- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: FOR OVERALL FINISH SEE SHEET 1
- 3) FINISH: SPRAY PAINT BLACK INSIDE SURFACE AFTER POWDER COAT  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE  
PER DART QSI 005 4.4 AFTER POWDER COAT
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004
- 10) TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION

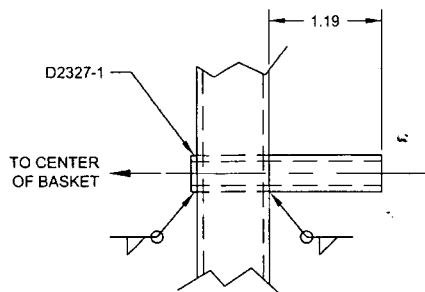
51182

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3266	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

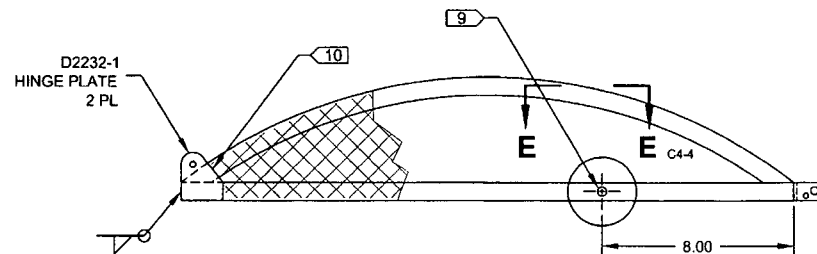
8 7 6 5 4 3 2 1



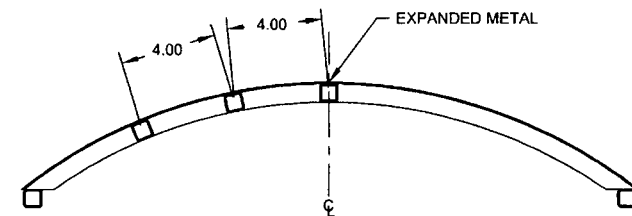




**VIEW E-E** B4-4  
SCALE 4X  
(BOTH ENDS)



**SECTION C-C** A4-2  
(BOTH ENDS)



**SECTION D-D** A1-2  
3 PL A2-2  
A3-2

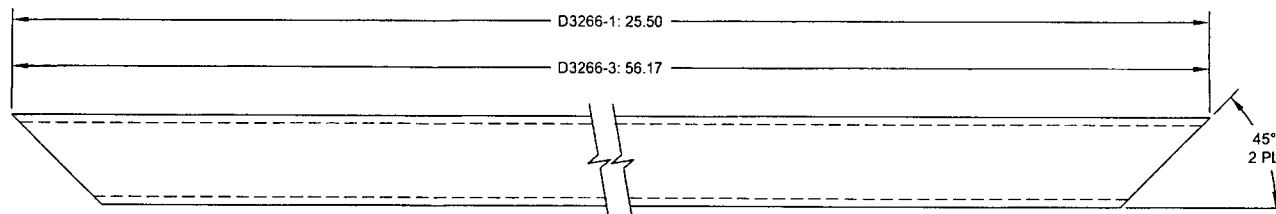
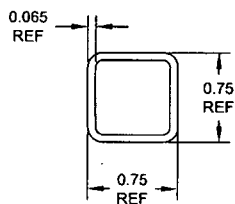
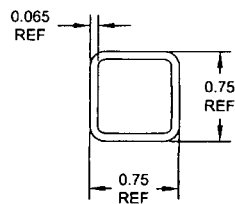
**NOTES:**

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-1 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS
- 10) TRIM MESH AS REQUIRED TO ALLOW D2232-1 HINGE PLATE TO SIT FLUSH ON FRAME

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RL</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>WJ</i>	D3266	SHEET 4 OF 5
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

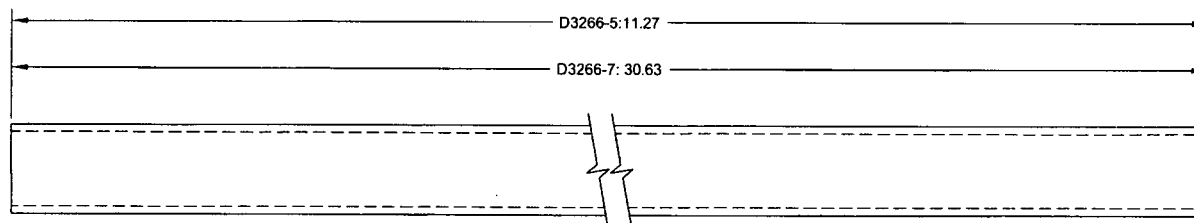
**RELEASED**  
02 09 04 10

51182



**D3266-1 RIB**

**D3266-3 RIB**



**D3266-5 RIB**

**D3266-7 RIB**

51182

**RELEASED**  
08-09-01-11

**RIB NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3266	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350)	NTS
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	